

Work Order ID 50968 - 2



Page 1

July 28, 2009 11:48:04 AM

Item ID:
Revision ID:
Item Name:

D3011-1
B
Rappel

Start Date:

31/07/2009

Required Date:

05/08/2009

Reference:

04 07 28

Split - 1

Accept



Setup Start



Stop



Start Qty:

10.00

Req'd Qty:

10.00

Cust Item ID:

Customer:



Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3011

Rev B

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks: 26.625"

0.00

0.00

MA 01/07/28

10



110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per folio FA129

Folio Rev: B

Dwg Rev: B

0.00

0.00

MA 09/08/01
88 09/08/09

5

Work Order ID 50968
 ly 28, 2009 11:48:04 AM



em ID:
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 Required Date:
 Reference:

D3011-1

B

Rappel

31/07/2009

Start Qty: 10.00

05/08/2009

Req'd Qty: 10.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
 Work Center ID

120



QC

Quality Control

130



QC

Quality Control

131



Outsource2

Outsource process - NDT

Operation
 Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/
 Run Hours

0.00

0.00

HA 07/08/01

QC8- Inspect parts - second check

Memo

0.00

0.00

2K 09/08/05

0.00

0.00

Memo

LPI AS PER ASTM 1417 LEVEL 2 AS PER DWG d3011

rec'd + attached report

P10.10194
 P10.10205

Draw
 Number

Draw
 Rev.

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

CL 09/08/11 (10)

CL 09/08/12 5

CL 09/08/11 10
 CL 09/08/12 5

ork Order ID 50968



by 28, 2009 11:48:04 AM

em ID:
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tem Name:
start Date:
Required Date:
Reference:

D3011-1

B

Rappel

31/07/2009

05/08/2009

Start Qty: 10.00

Req'd Qty: 10.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

132



QC

Quality Control

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

md 09 08 12

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

ll 09-08-13 X5

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

ll 09-08-13 X5

START TIME: 2:30pm
OVEN TEMPERATURE: 320°C
FINISH TIME: 2:30pm

M112260

2:30pm

320°C

2:30pm

140



HandFinish

Hand Finishing

150



Powdercoat

Powder Coating

Work Order ID 50968
 28, 2009 11:48:04 AM



m ID:
 vision ID:
 em Name:
 start Date:
 required Date:
 Reference:
 Approvals:

D3011-1

B

Rappel

31/07/2009

Start Qty: 10.00

05/08/2009

Req'd Qty: 10.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
 Work Center ID

160



QC

Quality Control

Operation
 Description

QC3- Inspect Part Finish

Set Up/
 Run Hours

0.00

Draw
 Number

Draw
 Rev.

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

Memo

0.00

=> 502/06/13

(X5)

5

Identify as per dwg & Stock Location: 54/87

0.00

~~502~~

Memo

0.00

LC 9/4/24 2 Stone
 3 Assy.

QC21- Final Inspection - Work Order Release

0.00

09/08/25

5 BA 09-8-24

Memo

0.00

170



Packaging

Packaging

180



QC

Quality Control

klist Print

28, 2009 11:48:04 AM

Page 1

rk Order ID: 50968
 ent Item: D3011-1RevB
 ent Item Name: Rappel
 omments:



Start Date: 31/07/2009

Required Date: 05/08/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
		Manufactured	No			110	f	14.0000	10.0000			

36202RevA
 I-Beam Extrusion



GA 09/07/28

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

14

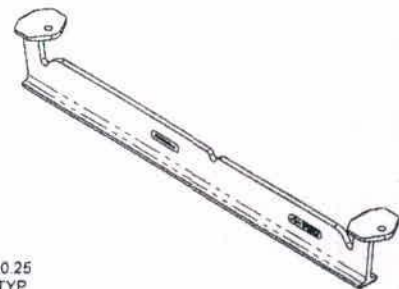
50040

14

50030

125'

22.6666



50968

RELEASED
09/07/28 MB

- NOTES:**
- 1) MATERIAL: MANUFACTURE FROM D6202-027 EXTRUSION
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3 5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.015 IN 0.19 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 3.00 lbs
 - 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING
 - 9) ENGRAVE "FWD" IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.015 IN
0.38 HIGH LETTERS WITH MIN TOOL RADIUS OF 0.015
 - 10) LPI PER ASTM 1417 LEVEL 2

B	UPDATE TO CURRENT STANDARDS; ADD NOTE 8; ADD SPOT FACE (ZN B2-1, B4-1 & D5-1); ADD DIMENSIONS (ZN B3-1, B4-1 & C3-1); 26.41 WAS 26.32 (ZN C4-1); 2.70 WAS 2.705 (ZN B7-1); ADD (+0.030/-0.010) TOLERANCES; ADD LPI (ZN A8-1)		RF	09.07.24
A	NEW ISSUE		CP	01.03.29
REV.	DESCRIPTION		BY	DATE
DESIGN	DSI	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV.	
MFG. APPR.	<i>[Signature]</i>	D3011	SHEET 1 OF	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	RAPPEL SLIDE BAR	NT.	
DATE	COPYRIGHT © 2001 BY DART AEROSPACE LTD.			
09.07.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL; IT IS LOANED TO YOU FOR YOUR PERSONAL USE ONLY. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			



LIQUID PENETRANT TEST REPORT

CLIENT DART AEROSPACE DATE AUG-10-2009 PAGE 1 OF 1
 ATTENTION LINDA CHANTAL ACUREN JOB NO. 188-09-001484 TIME AM ☒ PM ☐
 ADDRESS 1270 ABERDEEN ST. PO/WO NO. HAWKESBURY
HAWKESBURY ON. K6H-1K7 WORK LOCATION HAWKESBURY
 PROJECT F.P.I. ON MACHINED PARTS - AND CROSS TUBES ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
 ITEM(S) EXAMINED 44 STUDS. 20 RAPPELS
7 CROSS TUBES + 12 STUDS.

JOB DESCRIPTION WET FLOWESCENT LIQUID PENETRANT INSPECTION PROCEDURE NO. LT-0002 REV./DATE * TECHNIQUE NO. LT-TECH 2 REV./DATE *
 PART NO. WET FLOWESCENT LIQUID PENETRANT INSPECTION MATERIAL STAINLESS STEEL THICKNESS As Welded
 SCOPE CARRIED OUT 100% EXTERNAL

TEST DETAILS
 METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
 FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 OUTPUT > 1000 μ W/cm² AMBIENT < 2 fc
 PENETRANT 2L 07 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
 PENETRANT REMOVER H2O MINIMUM DRY TIME > 10 MIN. OTHER LABINO
 DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N DEC 8 - 2009
 DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
 SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
 SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
 14 PCS STUDS - W.O. 509 33 ✓
 30 PCS STUDS - W.O. 507 21 ✓ 24 X 0
 12 PCS STUDS - W.O. 509 32 ✓
 10 PCS RAPEL - W.O. 509 67 ✓
 10 PCS RAPEL - W.O. 509 68 ✓ 5 X 5
 1 CROSS TUBE - W.O. 510 83 ✓
 1 CROSS TUBE - W.O. 510 84 ✓
 1 CROSS TUBE - W.O. 510 85 ✓
 1 CROSS TUBE - W.O. 508 73 ✓
 1 CROSS TUBE - W.O. 508 27 ✓
 1 CROSS TUBE - W.O. 508 00 ✓
 1 CROSS TUBE - W.O. 508 26 ✓
 To Buff AND EXAMINE - INDICATION
 To Buff AND EXAMINE - INDICATIONS
 - 6 ITEMS TO EXAMINE AFTER BUFFING
 - OTHER PCS FOUND ACCEPTABLE TO STANDARD.

Scope of Services
 The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacturing, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
 Standard of Care
 In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
 CLIENT REPRESENTATIVE CHANTAL LAUDIN Chantal Laudin DTR # E-20068
 TECHNICIAN (SIGNATURE): Mike Johnston Mike Johnston REPORT REVIEWED BY:
 NAME (PRINT): Mike Johnston 1st TECHNICIAN Mike Johnston 2nd TECHNICIAN
 CGSB LEVEL 2 SNT LEVEL 6066 CGSB LEVEL 2 SNT LEVEL 6066
 CGSB REG. NO. 6066 CGSB REG. NO. 6066



LIQUID PENETRANT TEST REPORT

P- 14946

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE Aug 12-2009 TIME AM ☒ PM ☐
ATTENTION LINDA/CHARTER ACUREN JOB NO. 188-09-001485
ADDRESS 1270 ABBEYDEN ST. ON. PO/VO No. 10205
KGA 1K7 WORK LOCATION HAWKESBURY - ON.
ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON MACHINED PARTS AND
ITEM(S) EXAMINED CROSS TUBES
- EXAMINE - W.O. 50721 - ONE STUD, W.O. 50768 - 5 RAPS

JOB DESCRIPTION PROCEDURE No. LT 0002 REV./DATE * TECHNIQUE No. LT 1042 REV./DATE *
PART NO. WET FLOUORESCENT LIQUID PENETRANT INSPECTION MATERIAL STAINLESS STEEL THICKNESS ALUMINUM
SCOPE CARRIED OUT 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LAB. NO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY DEC 8 - 2009.

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
1 - STUD, W.O. 50721 ✓
5 - RAPS, W.O. 50768 ✓
1 - CROSS TUBE, W.O. 50801 ✓
1 - CROSS TUBE, W.O. 50877 ✓
12 - STUDS, W.O. 50721 ✓
ITEM WAS BUFFED-AND FOUND ACCEPTABLE
ITEMS WERE BUFFED-AND FOUND ACCEPTABLE
- WORK RAPS EXAMINED ON THIS REPORT HAVE BEEN FOUND ACCEPTABLE TO SET STANDARD.
MM 09 08 12

Scope of Services
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Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Ben Tittley PRINT Ben Tittley SIGNATURE
TECHNICIAN (SIGNATURE): Mike Johnston PRINT Mike Johnston SIGNATURE
NAME (PRINT): Mike Johnston 2ND TECHNICIAN
CGSB LEVEL II SNT LEVEL 6000 CGSB LEVEL II SNT LEVEL 6000
CGSB REG. No 6000 CGSB REG. No 6000
DTR # E-20069
REPORT REVIEWED BY: NAME INITIALS